

Work Order ID 85248

June-05-12 9:10:52 AM

85248

Page 3

Item ID: D412-742-043

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Replacement Float Skidtube

Stop

NS2Start Date: 05/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

120

QC5- Inspect part completeness to step on W/O

120

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

S120610

0.00

130

130

Packaging

Packaging

0.00

PP85244

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MWD 12/06/12

MF
(2/06/12)

Picklist Print

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Page 1

Work Order ID: 85248

85248
D412-742-043

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC
 11.11.01 as per DSI9517 REV.B DD verified by:EC

IPP Rev:F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3391-021
D3391-021
 Fwd Tube Assembly

D3391-023
D3391-023
 Mid Tube Assembly

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			FP	1		
			GA	-1		
D3391-025 *D3391-025* Aft Tube Assembly	Manufactured	No	110	Each	0.0000	1 ** B84683 (1x) M1106118

AN3C4A *AN3C4A* BOLT	Purchased	No	110	Each	1,362.000	24 ** M1106118
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST350	1362	
120187	57	
120521	28	
120769	38	
121205	1000	
121556	239	

124

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Offset/Setup										
Other										
Process										
Supplier										
Training										
Unauthorized										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many		General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing		<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material		<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Work Order ID: 85248

85248

Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

110

Each

451.0000

10

10

**

HL 110618

AN3C6A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FP001	1	
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111982	1	
--------	---	--

ST351	450	
-------	-----	--

111982	2	
--------	---	--

116419	23	
--------	----	--

116549	2	
--------	---	--

116704	12	
--------	----	--

117619	10	
--------	----	--

117688	1	
--------	---	--

117872	5	
--------	---	--

118422	13	
--------	----	--

119449	21	
--------	----	--

120423	3	
--------	---	--

120693	158	
--------	-----	--

121682	200	
--------	-----	--

X10

AN3C7A

Purchased

No

110

Each

140.0000

4

4

**

HL 110616

AN3C7A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	140	
-------	-----	--

113149	14	
--------	----	--

116169	1	
--------	---	--

117313	10	
--------	----	--

117619	12	
--------	----	--

117688	6	
--------	---	--

119749	1	
--------	---	--

120731	8	
--------	---	--

121185	50	
--------	----	--

121541	38	
--------	----	--

X4

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Engineering <input type="checkbox"/>			
Part No. _____			Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Quality <input type="checkbox"/>			
NCR No. _____				Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Offset/Setup												
Other												
Process												
Supplier												
Training												
Unauthorized												
FAULT CATEGORY												
Landing Gear	Bending Passes Below Min			Hardware			General					
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Breaking <input type="checkbox"/>	Missing <input type="checkbox"/>	Size/Length <input type="checkbox"/>	Burrs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Documentation/Data <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Set-up <input type="checkbox"/>
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Spinning <input type="checkbox"/>	Threading <input type="checkbox"/>	Wrong <input type="checkbox"/>	Finish <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Inspection Unqualified <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Supplier <input type="checkbox"/>
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Ripples on Inner Bend <input type="checkbox"/>	Torque Waves in Extrusion <input type="checkbox"/>	Drill Holes	Misaligned <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Over/Undersized <input type="checkbox"/>	Off-Set <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Turning Sequence <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Too Many <input type="checkbox"/>		Kit Incorrect <input type="checkbox"/>	Kit Missing <input type="checkbox"/>	Jigs/Fixtures/Tooling <input type="checkbox"/>	Orientation Misread <input type="checkbox"/>	Weld <input type="checkbox"/>
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							Out of Calibration <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							Out of Sequence <input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							Outside Dimensions <input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							Over/Under tolerance <input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							Part Lost <input type="checkbox"/>		
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							Part Moved <input type="checkbox"/>			
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							Raw Material <input type="checkbox"/>			

Picklist Print

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Page 3

Work Order ID: 85248

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

85248
D412-742-043

Start Date: 05/06/2012

Start Qty: 1.00

Required Date: 19/06/2012

Required Qty: 1.00

AN960C10L	<u>NAS1149C0332</u>	Purchased	No	110	Each	0.0000	38	38
-----------	---------------------	-----------	----	-----	------	--------	----	----

AN960C10I ✓
washer

11172063 ** (x38) M 110615

D4095-041	Manufactured	No	110	Each	0.0000	1	1
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D4095-041

Wearplate Assembly

B81623 ** (x1) M 110615

D4095-043	Manufactured	No	110	Each	1.0000	1	1
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D4095-043

Wearplate Assembly

B81624 ** (y1) M 110615

D4095-045	Manufactured	No	110	Each	15.0000	1	1
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D4095-045

Wearplate Assembly

** M 110615

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FP001
81624

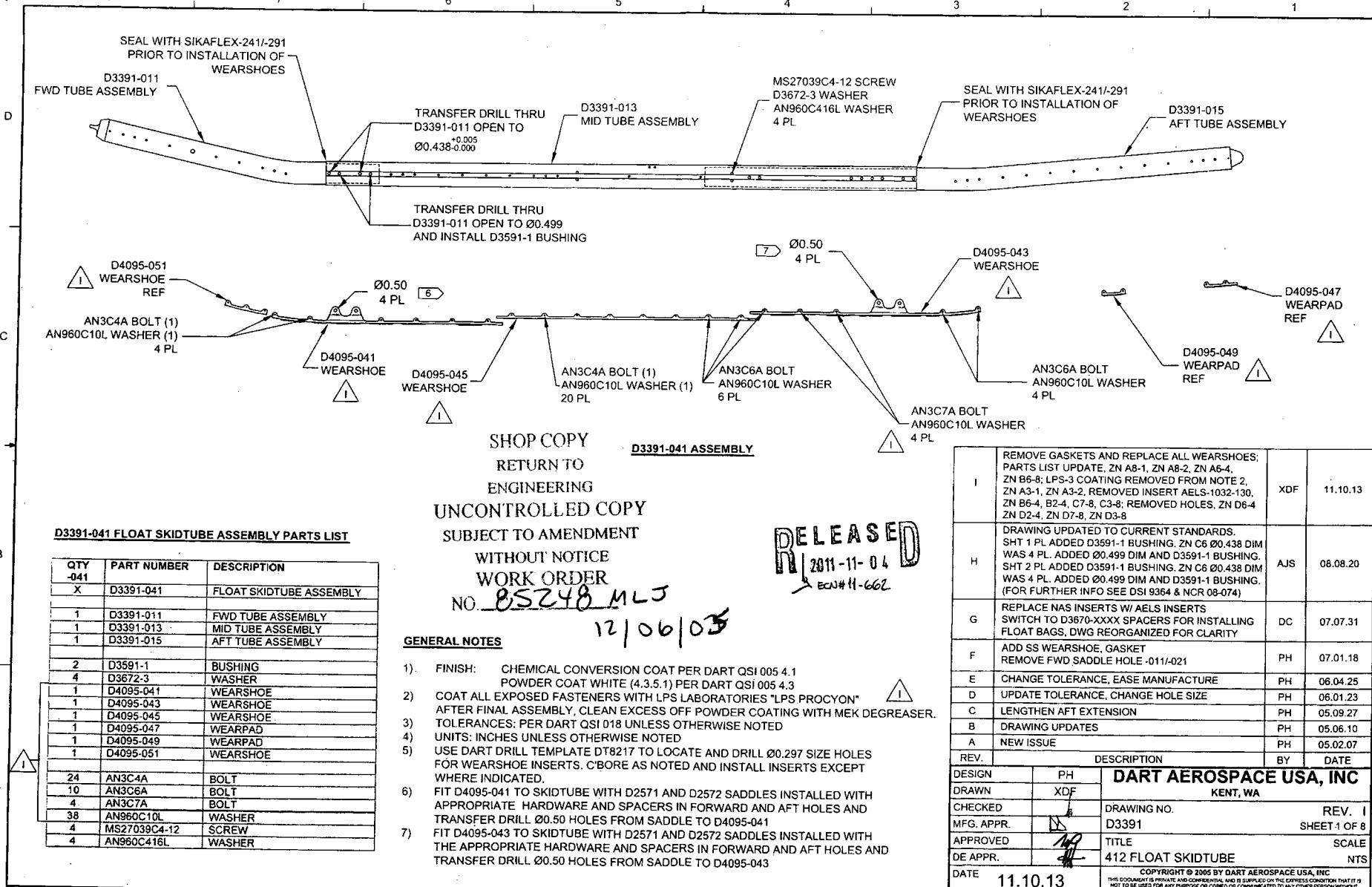
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1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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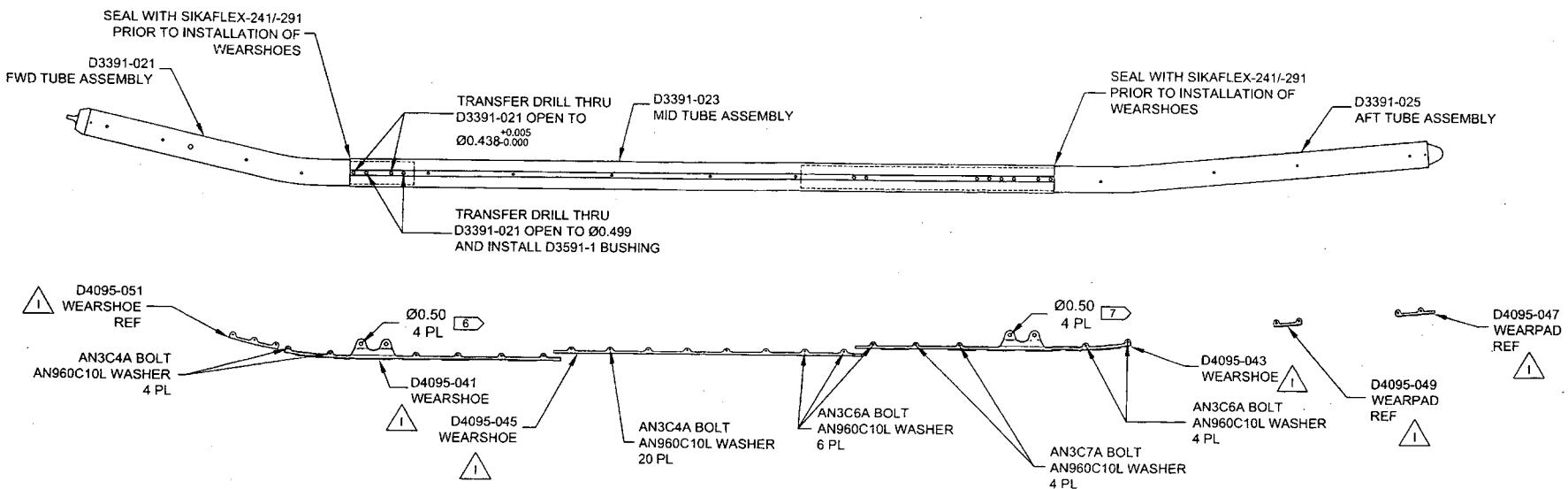
FP
81625
FP001
77737
84081

1
1
14
1
13

X1



05248



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN950C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-043

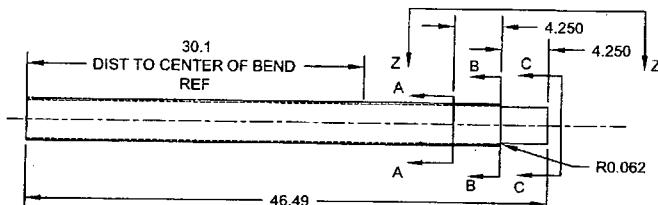
RELEASE
2011-11-04

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CHECKED		DRAWING NO.	REV. I	
MFG. APPR.		D3391	SHEET 2 OF 8	
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DE APPR.		412 FLOAT SKIDTUBE	NTS	
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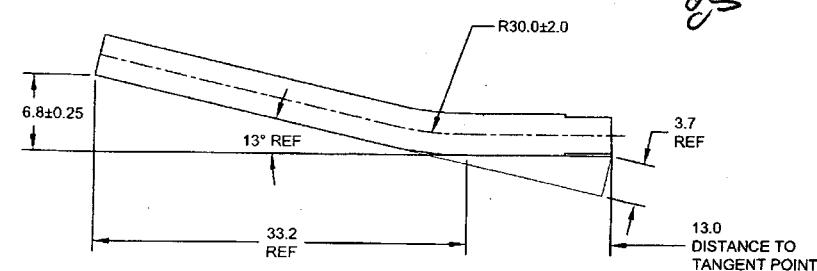
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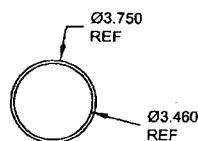
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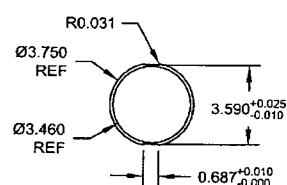
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



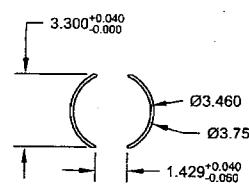
D3391-011/021 BENDING DETAIL
(MAKE FROM D3391-1)



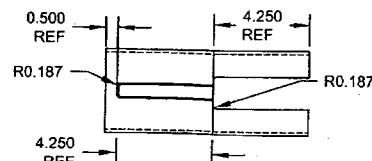
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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8 7 6 5 4 3 2 1

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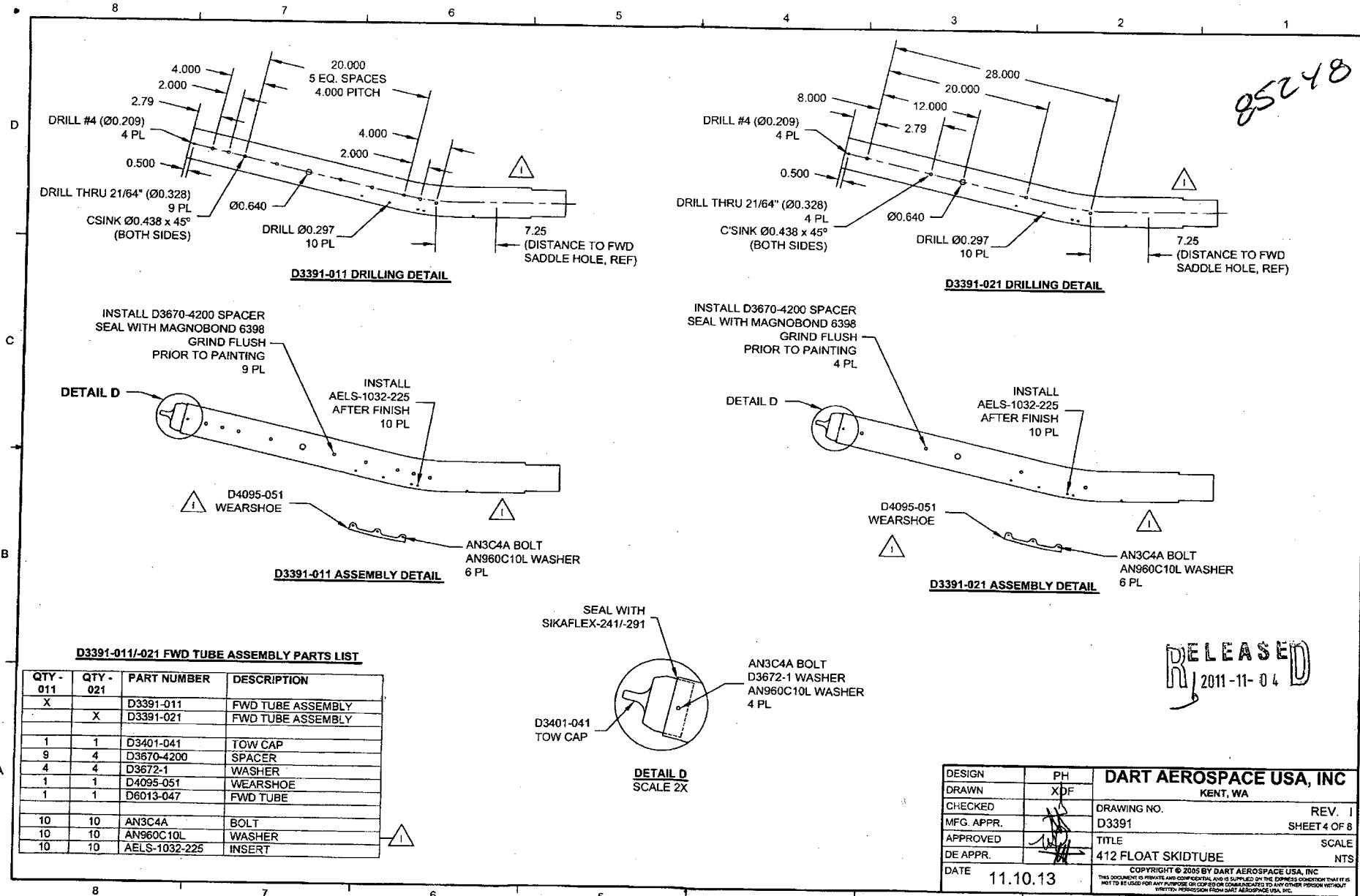
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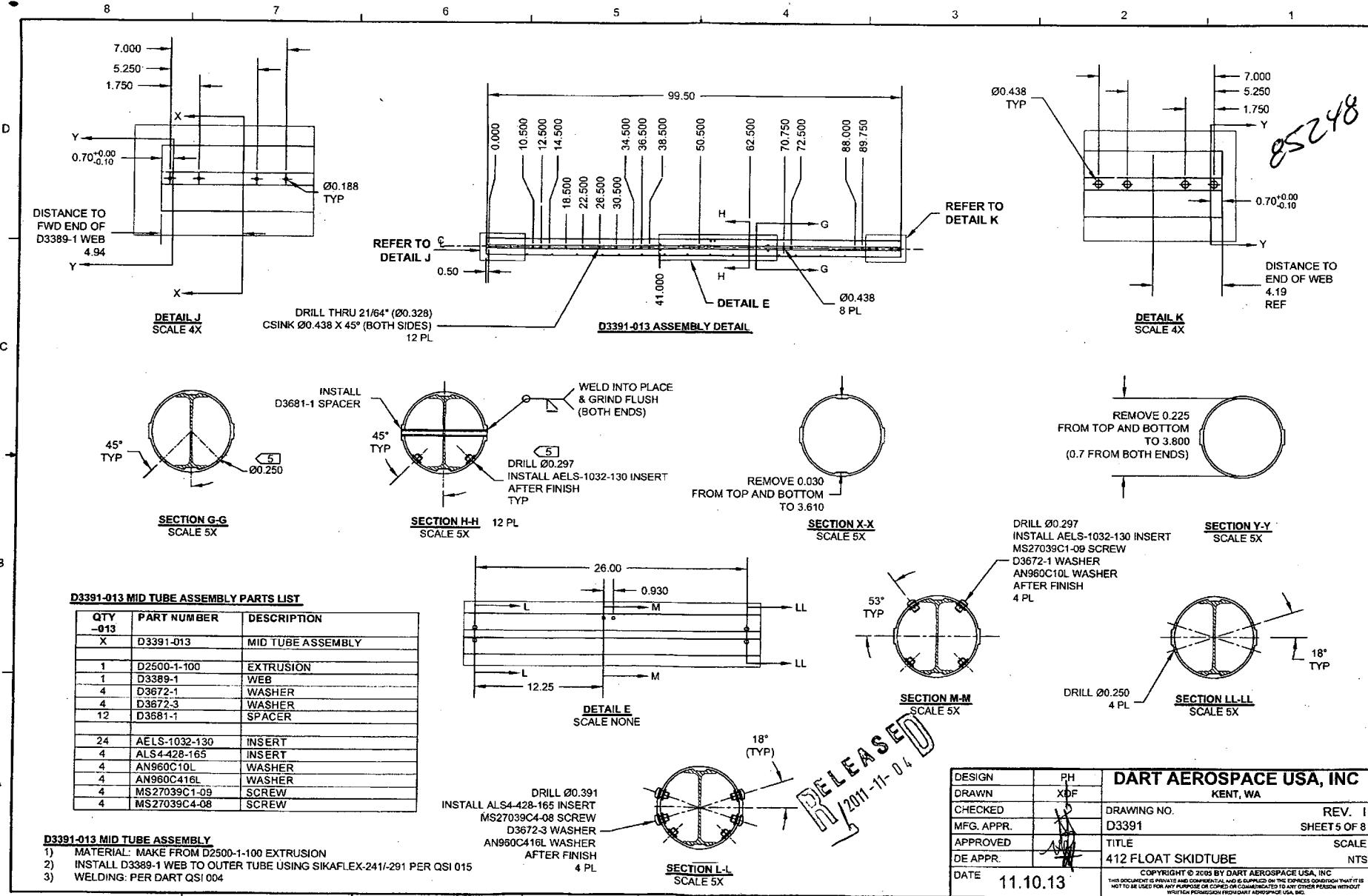
B

A

D



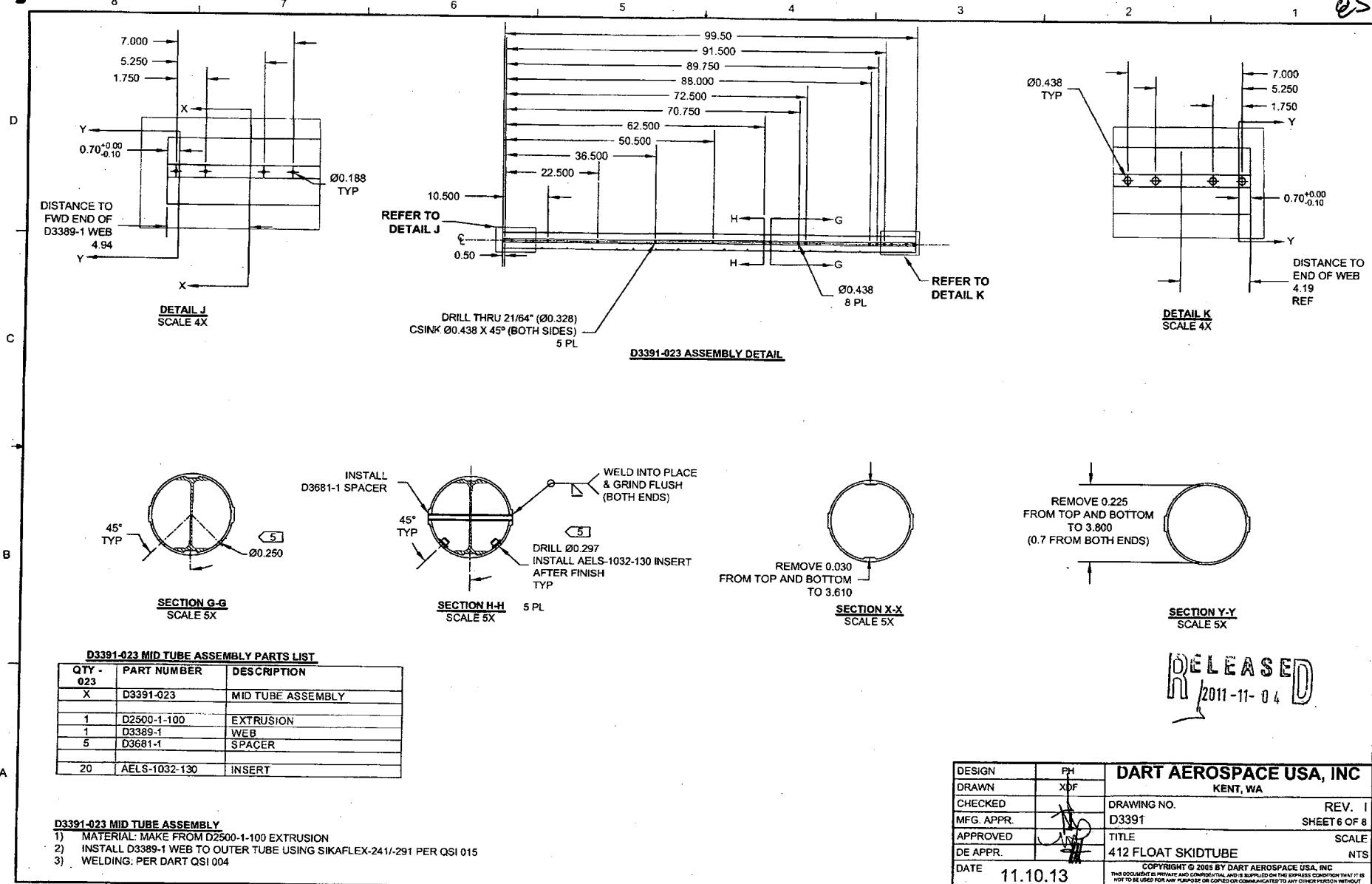
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2011-11-04

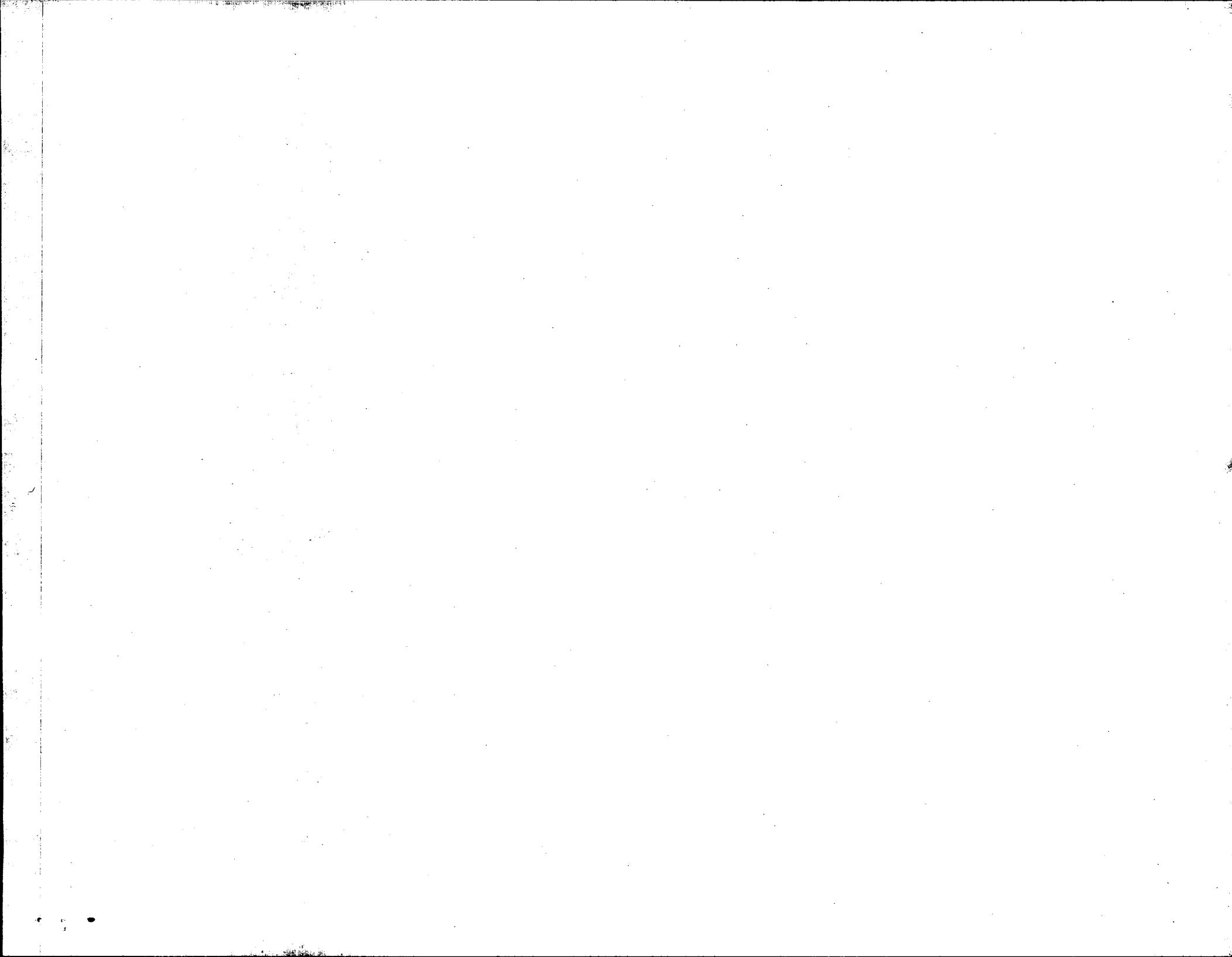


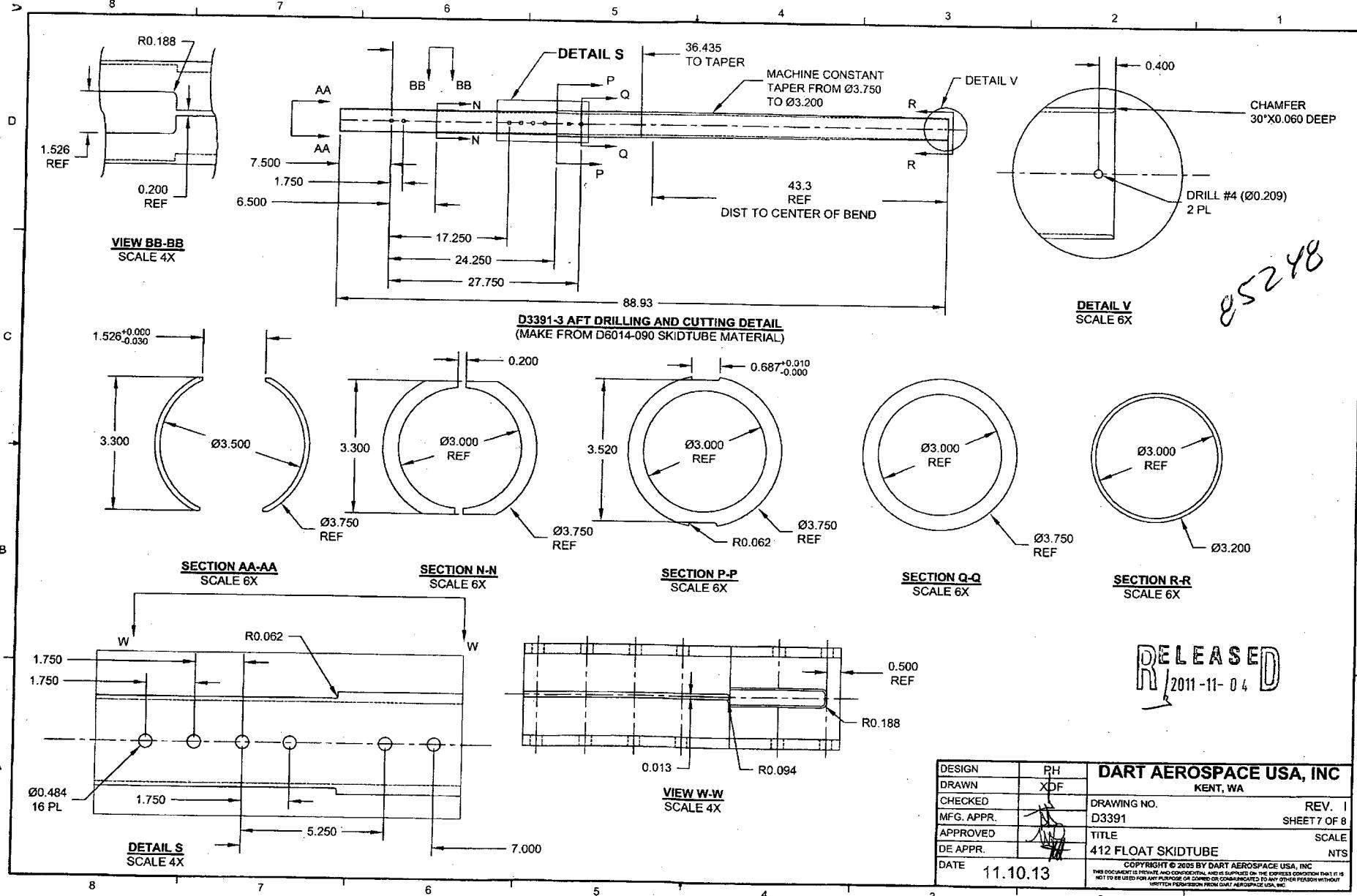
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DE APPR.	X	412 FLOAT SKIDTUBE	NTS	
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DESIGN	RH	DART AEROSPACE USA, INC
DRAWN	XDF	KENT, WA
CHECKED		REV. 1
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APPROVED		TITLE
DE APPR.		SCALE
DATE	11.10.13	NTS

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2011-11-04

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